












Date: Monday, 02/03/2009 11:23:41 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: LATCH BRACKET
<b>Job Number</b>	: 46164		
<b>Estimate Number</b>	: 10994		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2583
<b>This Issue</b>	: 02/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D2583 REV. B
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b>	: B
<b>Previous Run</b>	: 43940	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 20/03/2009 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JLD 09.03.02</u>		
<b>Comment</b>	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM Est: D 06.07.21 Waterjet EC		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	<del>M5052H32S040</del>	5052-H32 .040 Sheet	
			
<b>Comment:</b> Qty.: 0.1227 sf(s)/Unit Total : 4.9098 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) <del>1</del> <del>158</del> Batch: <u>109058</u> , <u>ml 09 03 16</u>			
2.0	WATER JET	FLOW WATER JET	
			
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2583 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>  2-Deburr if necessary <u>ml 09 03 17</u> (40)			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 09 03 17</u> (40)			
4.0	QC8	SECOND CHECK	
			
<b>Comment:</b> SECOND CHECK <u>S 02/03/17</u> (40) counters			
5.0	BRAKE NC	NC BRAKE	
			
<b>Comment:</b> NC BRAKE <u>S 02/03/17</u> Deburr (40) Form on CNC Brake as per Dwg D2583 <u>S 09/03/19</u> (40)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 11:23:41 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 46164

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

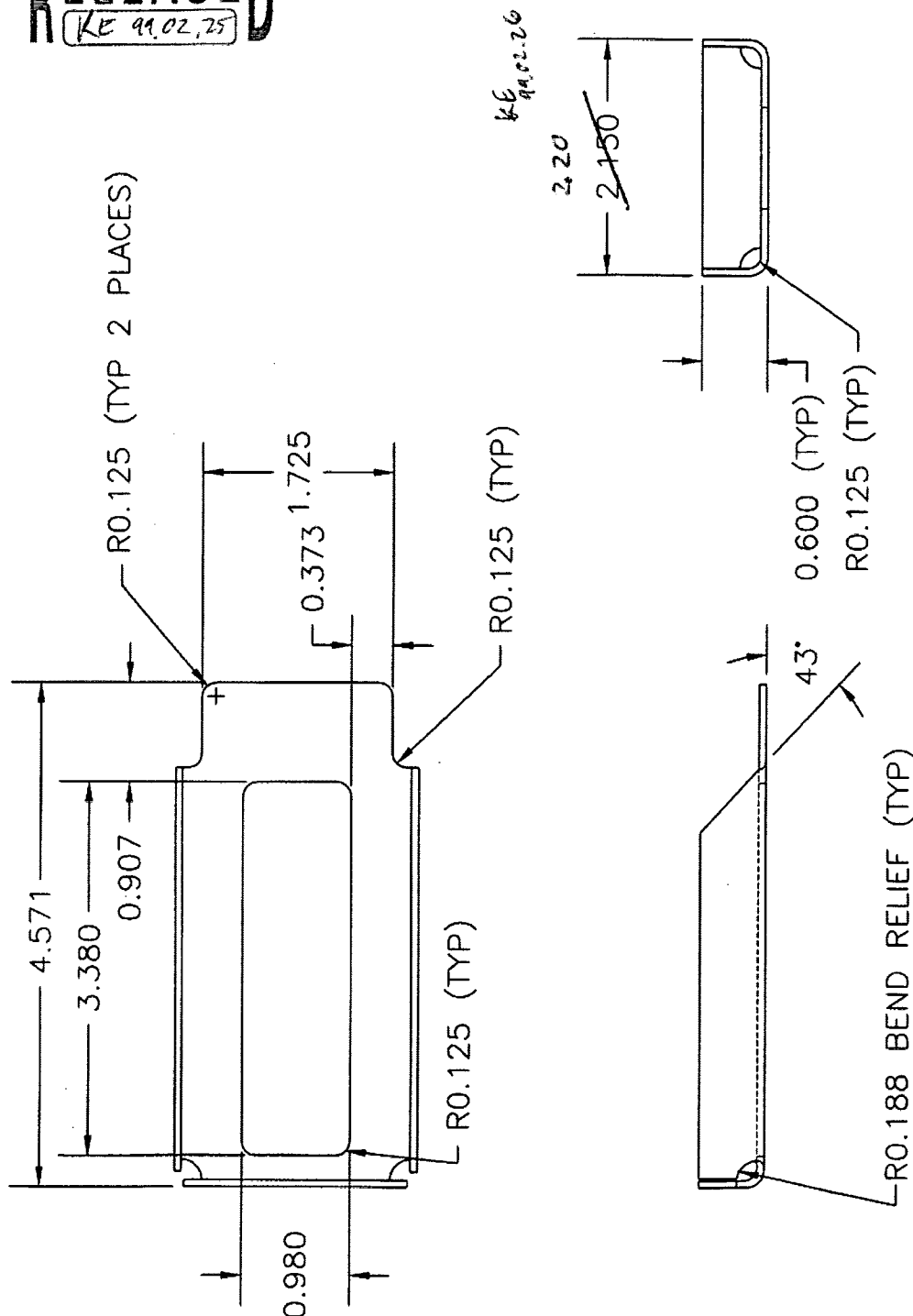
**NOTE:** Date & initial all entries





DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22		TITLE LATCH BRACKET	SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

RELEASED  
KE 99.02.25



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

Copyright 1996 by DART AEROSPACE LTD

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 76164